

EUROPEAN PATENT OFFICE

Patent Abstracts of Japan

PUBLICATION NUMBER : 58181619
PUBLICATION DATE : 24-10-83

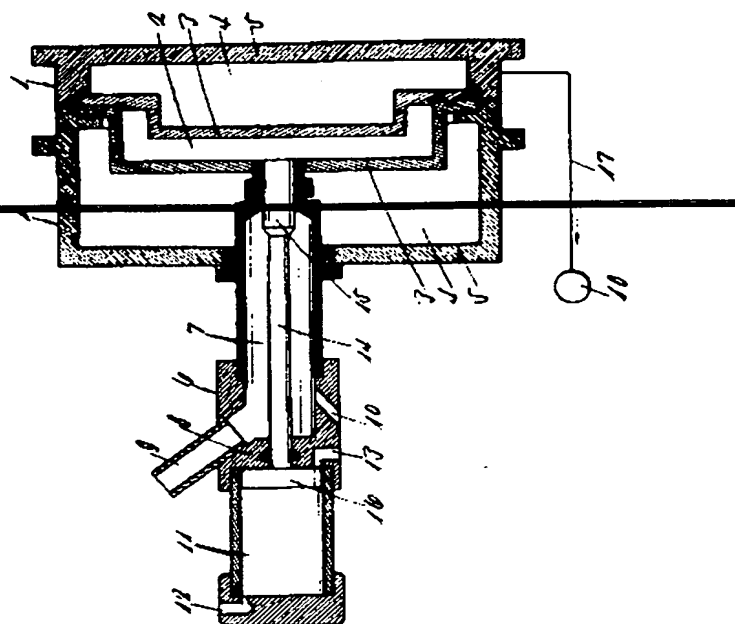
APPLICATION DATE : 16-04-82
APPLICATION NUMBER : 57064498

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INT.CL. : B29D 27/00

TITLE : FILLING WITH BEADS AS MATERIAL
OF FOAMED STYRENE



ABSTRACT : PURPOSE: To fill the cavity of a mold under uniformed state with material beads in the foamed styrene bead filling method by a method wherein molds are closed, a negative pressure is made in the heating chamber and the cavity, while the opening end of the supply cylinder is opened and material beads are sucked into the cavity.

CONSTITUTION: Molds 1, 1 are closed, the closing and opening piston 15 is advanced, the opening end of the supply cylinder 7 is closed to absorb air in both heating rooms by the suction apparatus 18 and make a vacuuous state in the heating rooms 4. At this time, since the air also in the cavity 2 is absorbed from a slit equipped on the die plate 3, the inner portion also in the cavity forms a vacuum. Then, the material beads in the hopper can be supplied from the material supply hole 9 into the supply cylinder 7 and the air cylinder 11 is operated to open the opening end of the supply cylinder 7. Then, the material beads are absorbed into the cavity 2. In this way, the cavity can be filled equally.

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